

Date: Friday, 19/06/2009 10:14:07 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RIB			
Job Number	: 48666		Part Number	: D25127			
Estimate Number	: 13578		Drawing Number	: D2512 REVE (PG.1)			
P.O. Number	:		Project Number	: N/A			
This Issue	: 19/06/2009	S.O. No. :	Drawing Revision	: E			
Prsht Rev.	: NC		Material	:			
First Issue	: / /	Type	: LARGE FAB ASSY				
Previous Run	: 48326		Due Date	: 26/06/2009		Qty: 4 Um: Each	
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 08-12-02 DD verified by:						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
<p>Comment: Qty.: 2.6801 f(s)/Unit Total : 10.7205 f(s)            304 SQ Tube .75x.75x.065W            batch: <u>112051</u></p> <p><i>SAD 09-06-19 (4)</i></p>			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
<p>Comment: LARGE FABRICATION RESOURCE 1</p> <p><i>✓1- Cut as per dwg D2512        ✓2- Deburr and remove identification markings on tube</i></p> <p><i>SAD 09-06-22 (4)</i></p>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p><i>SAD 09-06-22 (4)</i></p>			
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
<p>Comment: PACKAGING RESOURCE #1</p> <p>Identify and Stock            Location: <u>WA</u></p> <p><i>SAD 09-06-22 (4)</i></p>			
5.0	QC21	FINAL INSPECTION/W/O RELEASE	
<p>Comment: FINAL INSPECTION/W/O RELEASE</p> <p><i>09/06/23 (4)</i></p>			
Job Completion			
<p><i>MF 09-06-22</i></p>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

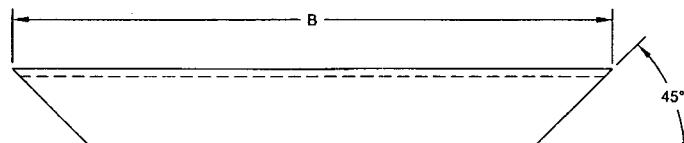
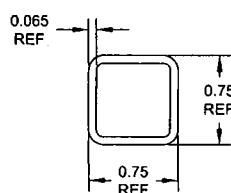
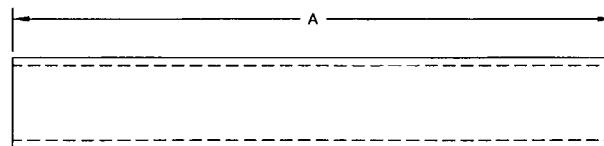
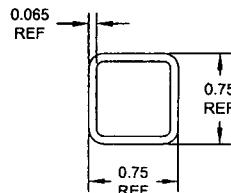
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

### PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	_____	25.50	RIB
D2512-3	2	_____	95.30	RIB
D2512-5	6	30.84	_____	RIB
D2512-7	3	30.63	_____	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



**E**

**D2512-1/-3/-5/-7 NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

**RELEASED**  
08-08-21-14

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3. ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		REV. E	
MFG. APPR.		DRAWING NO.	
APPROVED		D2512	SHEET 1 OF 4
DE APPR.		TITLE	SCALE
		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE WHATSOEVER BY ANY PERSON UNLESS AUTHORIZED BY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

A

D

C

B

A

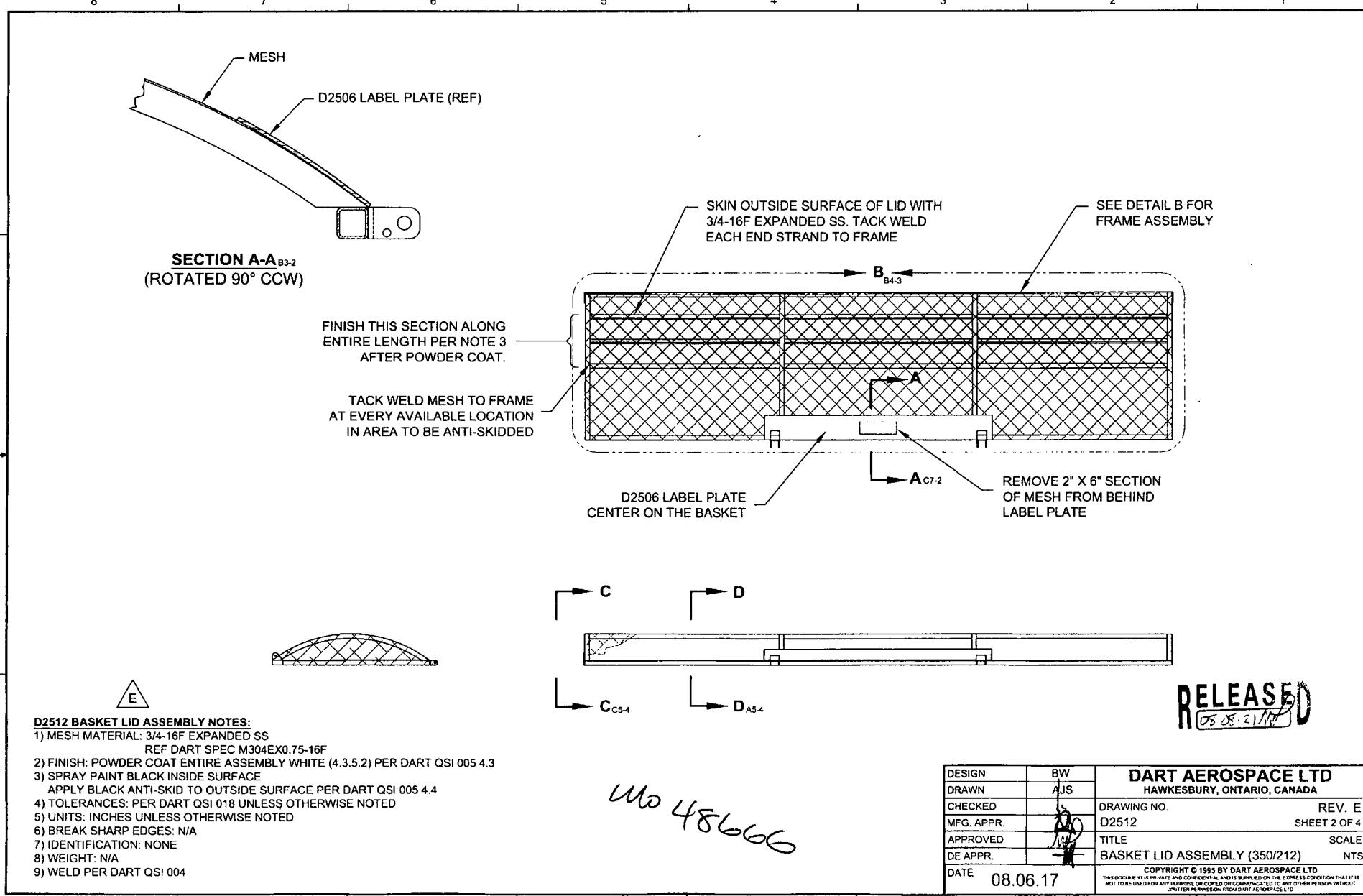
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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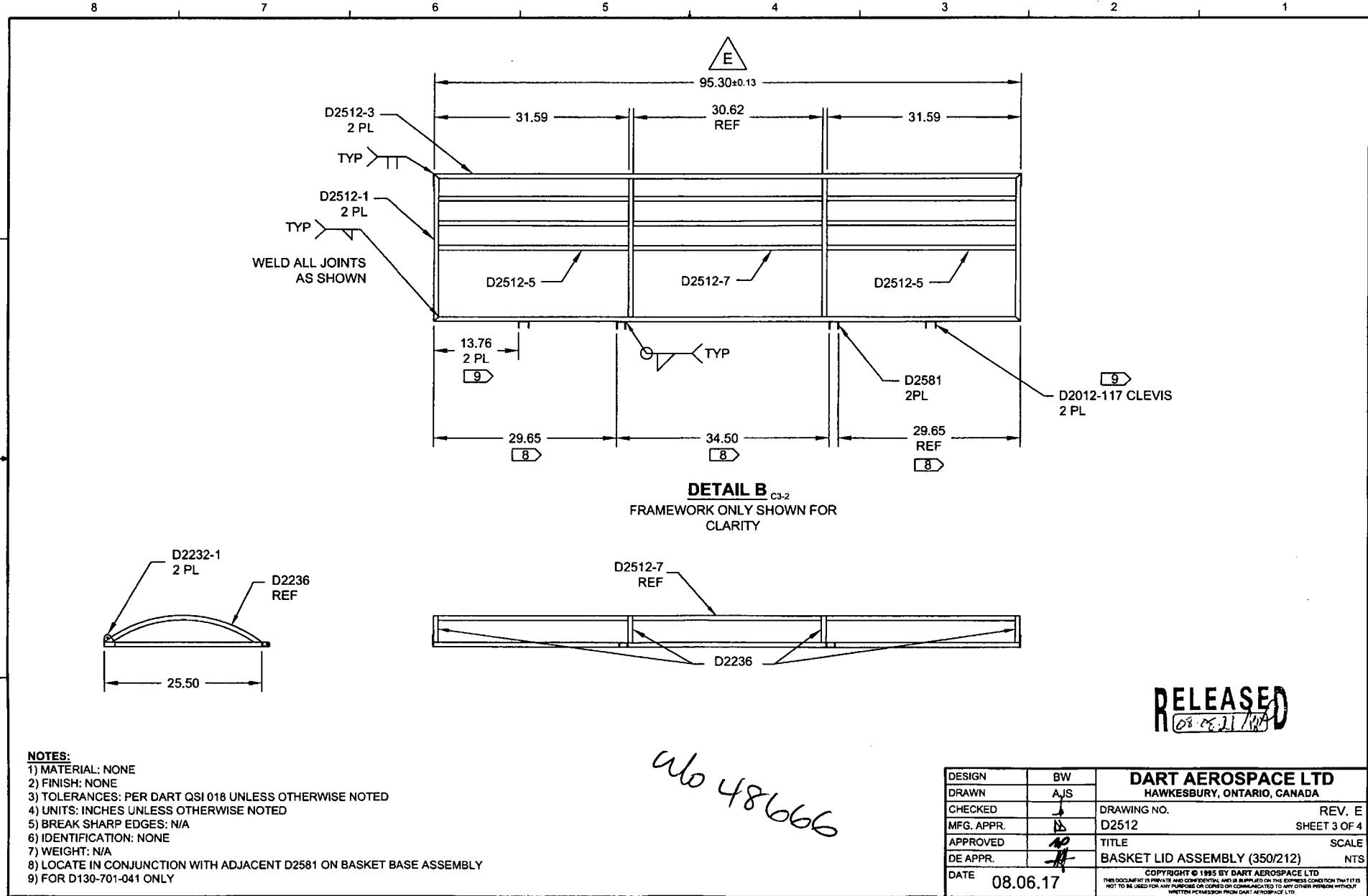
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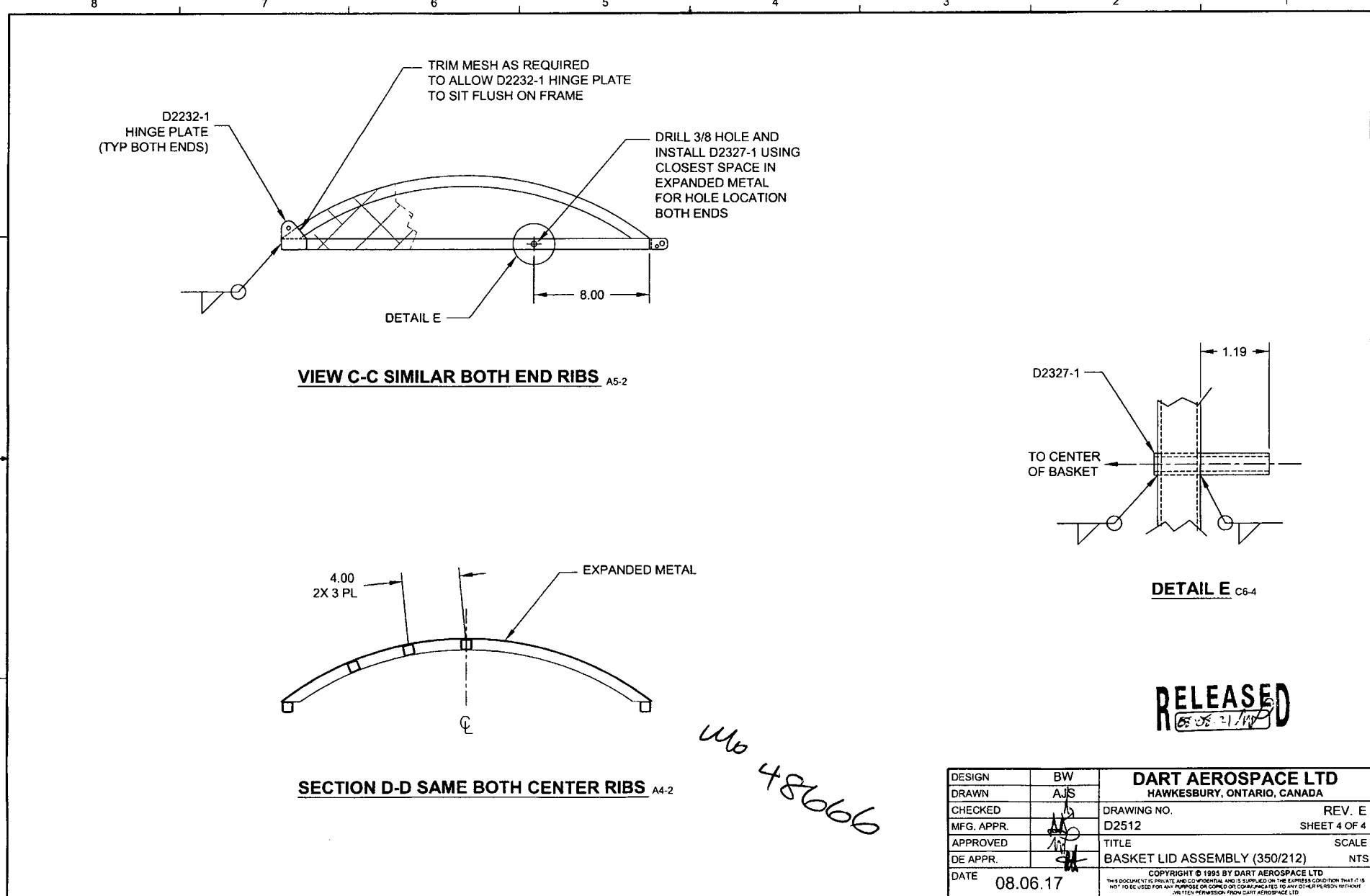
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO. REV. E	
MFG. APPR.	<i>AS</i>	D2512	SHEET 4 OF 4
APPROVED	<i>AS</i>	TITLE	SCALE
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